

Re-Print



Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200
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D3201-1
Job Sheet 194882

Part No: D3201-1

Part Name: Doubler

Job Qty: 12 pcs

11/15/19
DAS
8-49



Part Weight: 0 lbs

Job Created: 5/9/19

Due Date: 11/26/19

Type: Stock

Status: New

Job Tracking No:

Created By: Marie Lajeunesse

Description:

Priority: Medium

Note: DWG REV B IPP Rev:A Removed from 9 Digit 06-01-25 JLM IPP Rev:B Now on Waterjet 06-08-14 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Run Hrs	Hrs	Workcenter/Supplier	Lead Time	Sign-off
100	Waterjet - Flow - 1	12	11/26/19	11/26/19	0.00	0.45	Waterjet - Flow		
120	QC 8	12	11/26/19	11/26/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		

PRIORITY



Container No: S231186



Part: D3201-1

Job No: 194882

Serial No/Batch: S231186

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/12/19

Dart Aerospace Ltd.

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140 Handfinish - 1-1 Chemical-B4B	12 pcs	11/26/19	0.00 0.45	QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	

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150 QC 7	12 pcs	11/26/19	0.00 0.00	Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
				QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
160 Packaging 3-1 - Stock - B4B	12 pcs	11/26/19	0.00 0.00	QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
NOV 15 2019 <i>Discor</i>	15 pcs	11/26/19	0.00 0.00	QC 7 - 67	NOV 13 2019 40 DAS
				QC 7 - 40	9-89
				QC 7 - 24	
				QC 7 - 43	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B ✓	ST023
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
NOV 14 2019				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	

Packaging 3 - 11 - B4B	
Packaging 3 - 12 - B4B	
Packaging 3 - 13 - B4B	
Packaging 3 - 14 - B4B	
Packaging 3 - 15 - B4B	
Packaging 3 - 16 - B4B	
Packaging 3 - 17 - B4B	
Packaging 3 - 18 - B4B	
Packaging 3 - 19 - B4B	
Packaging 3 - 20 - B4B	
Packaging 3 - 21 - B4B	
Packaging 3 - 22 - B4B	
Packaging 3 - 23 - B4B	
Packaging 3 - 24 - B4B	
Packaging 3 - 25 - B4B	
Packaging 3 - 26 - B4B	
Packaging 3 - 27 - B4B	
Packaging 3 - 28 - B4B	
Packaging 3 - 29 - B4B	
Packaging 3 - 30 - B4B	
Packaging 3 - 31 - B4B	
Packaging 3 - 32 - B4B	
Packaging 3 - 33 - B4B	
Packaging 3 - 34 - B4B	
Packaging 3 - 35 - B4B	

170 QC 21 - SA	15 12 pcs	11/26/19	0.00 0.00	B4B	
				Packaging 3 - 36 - B4B	
				QC 21 - SA - 21	✓
				QC 21 - SA - 70	das
				QC 21 - SA - 53	21

Part Op 100 - 1-Cut as per Dwg D3201

Descriptions: 120 - (QC8- Inspect parts - second check)

140 - (Chemical Conversion Coat per QSI005 4.1)

150 - (QC7-Inspect Chemical Conversion Coat)

160 - (Identify as per dwg & Stock Location:)

170 - (QC21 - Final Inspection - Work Order Release)

NOV 15 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Contalper
M2024T3S.040	2024-T3 .040 Sheet	3.3120 sf (.276 ea)	100-Waterjet - Flow - 1	52163112

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.040	3	231	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler	0.500inches ± 0.030	0.530 0.470		
2	Doubler	3.570inches ± 0.030	3.600 3.540		
3	Doubler	0.120inches ± 0.030	0.150 0.090		
4	Doubler	8.000inches ± 0.030	8.030 7.970		
5	Doubler	0.580inches ± 0.030	0.610 0.550		
6	Doubler	4.890inches ± 0.030	4.920 4.860		
7	Doubler	0.250inches ± 0.030	0.280 0.220		
8	Doubler	0.040inches ± 0.010	0.050 0.030		

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